

Work Order ID **77541**

Thursday, December 13, 2011 10:18:26 AM

Page 1

Item ID: D3806-1

Accept

N5 000 40100

Setup Start ***IIS1**

Revision ID:

Item Name: Bar

Stop ***IIS2**

Start Date: 12/14/2011 Star Qty: 20.0

***20**

Cus Item ID:

Required Date: 12/30/2011 Req Qty: 20.0

***20**

Cus Order:

Reference:

Approvals: Process Plan: _____ Date: _____

Tooling: _____ Date: _____

Run Start ***IIR1**

QC: _____ Date: _____

SPC (I/N): _____ Date: _____

Stop ***IIR2**

Sequence ID	Work Center ID	Operation Description	Set Up/Run Hours	Tool ID	Tool #	Plate Code	Accepted Qty	Rejected Qty	Rejected Number	Insp. Stamp
1	raw Nbr	Revision 1 br								
1	3806	3								

10

0.00

100

Cold Saw

Memo

0.00

Hy Mech

Cut blades at 43,600"

20 φ 11/12/19

11

0.00

110

HLAS1

Memo

0.00

HLAS CNC vertical machine #

1-Mill per folio FI 070 & dwg

FOLIO EV: AA

DWG FV: B

2-Debur as required

20 φ 11/12/19

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Item ID: D3806-

Accept

NS 0000 40100

Setup Start *IJS1:

Revision ID:

Item Name: Bar

Stop *IJS2:

Start Date: 12/14/2011 Star Qty: 20.0

*20:

Required Date: 12/30/2011 Req 1 Qty: 20.0

*20:

Cus Item ID:

Cus Order:

Reference:

Approvals:

Process Plan:

Date

Tooling:

Date:

Run Start

*IIR1:

QC:

Date

SPC (Y/N):

Date:

Stop

*IIR2:

Sequence ID:

Work Center ID

Operation

Description

Set Up/

Run Hours

Tool ID

Tool #

Pls i

Co e

Acce t

Qty

Rejec

Qty

Rejec

Number

Insp.

Stamp

12

QC2- inspect parts - machine F. WFAIB

0.00

120

QC

Memo

0.00

Quality Control

20

0

11/12/19

13

QC8- inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

B.A 11/12/19

20

0

13

Welder dwg A/R. Hardcoat S.S. batch: _____

0.00

133

La ge Fab

Memo

0.00

La ge Fab

1- On J 3806-1, fill it out with Hardcoat welding rod as per Wg D3805

2059 Hardcoat Welding Rod

BAT# _____

h

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Item ID: D3806-

Accept

NS 0000 10100

Setup Start *IJS1:

Revision ID:

Stop *IJS2:

Item Name: Bar

Start Date: 12/14/2011 Star Qty: 20.0

*20:

Cus Item ID:

Required Date: 12/30/2011 Req Qty: 20.0

*20:

Cus Order:

Reference:

Approvals: Process Plan: _____ Date: _____

Tooling: _____ Date: _____

Run Start *IJR1:

QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Stop *IJR2:

Sequence ID,
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Qty Accept Qty Reject Qty Reject Number Insp. Stamp

13

QC10 Inspect visually per QSI004. Ground welds

0.00

136

QC

Memo

0.00

Quality Control

will be done on
assembly w/o

13

QC5- inspect part completeness step on W/C

0.00

137

QC

Memo

0.00

Quality Control

14

Identify as per dwg. Stock Location: W/A

0.00

140

Packaging

Memo

0.00

Packaging

EL 11-12-21 420

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Item ID: D3806-

Accept

NS 000010100

Setup Start *IIS1:

Revision ID:

Stop *IIS2:

Item Name: Bar

Start Date: 12/14/2011 Star Qty: 20.0

*20:

Cus Item ID:

Required Date: 12/30/2011 Req Qty: 20.0

*20:

Cus Order:

Reference:

Approvals:

Process Plan:

Date

Tooling:

Date:

Run Start

*IIR1:

QC:

Date

SPC (U/N):

Date:

Stop

*IIR2:

Sequence ID:

Operation

Set Up/

Tool ID

Tool #

Pls i

Accept

Reject

Reject

Insp.

Work Center ID

Description

Run Hours

Code

Qty

Qty

Number

Stamp

15

QC21 Final Inspection - Work Order Release

0.00

150

Q

Memo

0.00

Quality Control

11/12/22
mf
91-12-21

Print

Thursday, December 13, 2018 10:18:24A

Page 1

Work Order ID: 775 1

Parent Item: D3806x1

Parent Item Name: Bar

Start Date: 12/14/2011

Required Date: 12/30/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev: A 08-07-21 new issue DD verified by:
 IPP Rev: B 08-09-23 redesign DD verified by: EC
 IPP Rev: C 08-09-30 redesign DD verified by: EC
 EC verified by: D IPP Rev: E 11.10.04 rev. based on per dwg DD verified by: EC
 IPP Rev: 11.06.01 re-design

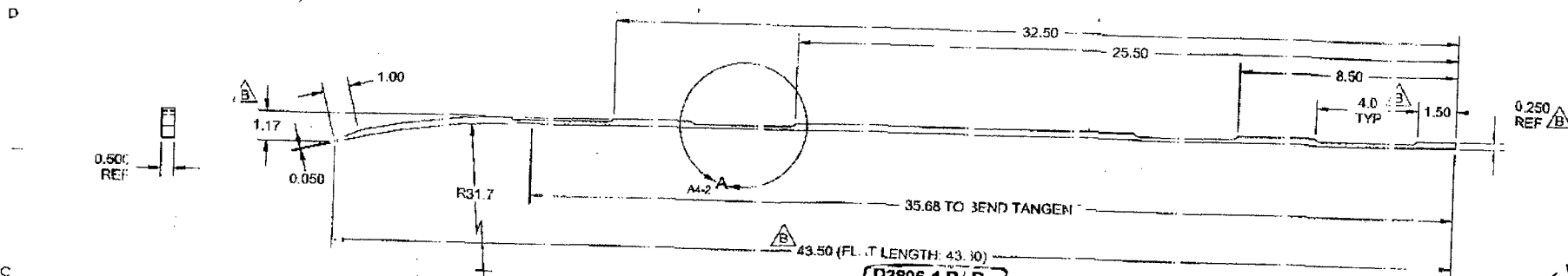
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purchase	Final Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M3 4B0.250x0.00		Purchased	No			100		010.816	3.66	77,052.63			
30 BAR.250x 00										84,400			

Location	Loc Qty	Loc Code
MATC 6	597.522	
117842	8.3	
119050	21.67	
119159	567.552	
MATC 0	413.2947	
117176	37.8947	
119872	375.4	

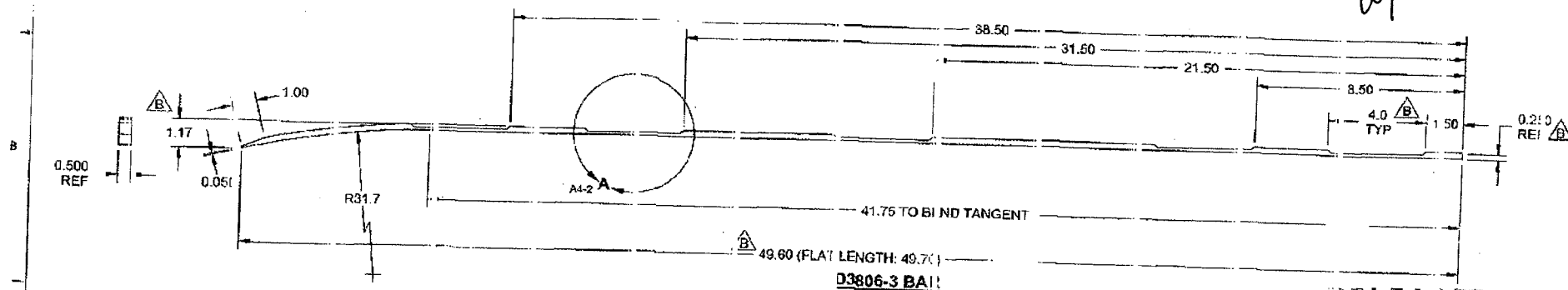
84,400

11/12/18

8 7 6 5 4 3 2 1



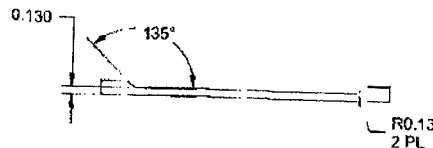
w/o 77541



RELEASED
2011-10-13
JH

NOTES:

- 1) MATERIAL: AISI 304/316; TAINLESS STEEL BAR, 0.250 x 0.500 THICK REF. DART SPEC. M304B0.250W00.500
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT:
D3806-1 = 1.27 lbs
D3806-3 = 1.42 lbs



DET. M/LA D6-2
TYP, SCALE 2X C3-3
A3-3

DESIGN	6	DAIT AEROSPACE USA, INC.	REV. B
DRAWN	10	DRAWING NO.	KENT NA
CHECKED	10	D3806	SHEET 2 OF 3
MFG. APPR.	10	TITLE	SCALE
APPROVED	10	BAR	NTS
DATE	11.09.29	<small> COPYRIGHT © 2008 BY DAIT AEROSPACE USA, INC. UNCLASSIFIED - NO RESTRICTIONS ON REPRODUCTION OR DISTRIBUTION NOT TO BE USED FOR PROPRIETARY PURPOSES WITHOUT WRITTEN PERMISSION </small>	